

Date: Thursday, 5/4/2006 10:46:27 AM  
User: Kim Johnston

# **Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 26974  
Estimate Number : 10533  
P.O. Number : N/A  
This Issue : 5/4/2006 S.O. No. : N/A  
Prsht Rev. : NC  
First Issue : N/A Type : MACHINED PARTS  
Previous Run : 26562  
Part Number : D2573  
Drawing Number : D2573 REV E  
Project Number : N/A  
Drawing Revision : E  
Material : N/A  
Due Date : 5/25/2006 Qty: 12 Um: Each  
Written By : SKA COMMENT BELOW  
Checked & Approved By : OK 05.04  
Comment : Est: 1 As Per RevE 06-01-27 JLM

## **Additional Product**

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)  
7075-T7351 8.25X7.75X2.5  
Make from D6101-007 billet for D2573  
Ensure that grain is along 7.75" length  
Batch No: B24070

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No 26974 Double check by: J.L

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove sharp edges.

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2573 & D2574

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 26974

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

BC 06-06-13

1

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Q.M 06-06-13

(6)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M 06-06-13

(6)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 6/6/14 (6)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: styfu

P 6/6/14 (6)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

P 6/6/14 (6)

Job Completion



U 06/06/14





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26974
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	✓	0.440	0.440	✓		
B	1.745	1.755		1.748	1.749	1.750	1.746		
C	3.495	3.505		3.499	3.499	3.501	3.488		
D	1.745	1.755		1.743	1.750	1.750	1.746		
E	7.990	8.010		2.999	8.001	8.003	8.004		
F	0.490	0.510		0.490	0.497	0.498	0.494		
G	0.257	0.262	DT8683		0.258	0.258	✓		
H	0.375	0.380	DT8684	✓	0.376	0.376	✓		
I	0.490	0.510		0.490	0.499	0.501	0.498		
J	1.174	1.184		1.178	1.180	1.180	1.178		
K	0.558	0.578			0.566	0.568	0.566		
L	1.174	1.184		1.178	1.180	1.180	1.178		
M	1.365	1.375			1.371	1.372	1.368		
N	2.495	2.505			2.497	2.497	2.497		
O	4.119	4.129			4.121	4.121	4.126		
P	0.115	0.135			0.124	0.124	0.127		
Q	0.115	0.135			0.134	0.134	0.135		
R	0.240	0.260			0.247	0.246	0.252		
S	0.115	0.135			0.116	0.115	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250			3.231	3.232	3.230		
V	0.230	0.250		0.233	0.235	0.234	0.232		
W	0.115	0.135			0.118	0.114	0.125		
X	0.308	0.313			0.310	0.310	0.310		
Y	0.760	0.765			0.761	0.761	0.765		
Z	0.352	0.372		0.372	0.364	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.243	0.241	0.242	0.240		
AE	1.500	1.520		1.513	1.518	1.518	1.515		
AF	0.115	0.135		0.127	0.127	0.126	0.135		
AG	0.240	0.280		0.272	0.270	0.265	0.260		
AH	0.240	0.260		0.245	0.240	0.241	0.243		
AI	2.000	2.020		2.006	2.005	2.006	2.001		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: S.G.
Date: 06/05/25

Audited by: En
Date: 06/06/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26974
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E	<b>Page 1 of 1</b>

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C	3.495	3.505		3.498	3.499	3.499			
D	1.745	1.755		1.746	1.746	1.746			
E	7.990	8.010		8.004	8.002	8.000			
F	0.490	0.510		0.495	0.495	0.499			
G	0.257	0.262	DT8683	0.258	—	—			
H	0.375	0.380	DT8684	0.376	—	—			
I	0.490	0.510		0.496	0.496	0.496			
J	1.174	1.184		1.175	1.175	1.175			
K	0.558	0.578		0.563	0.563	0.563			
L	1.174	1.184		1.175	1.175	1.175			
M	1.365	1.375		1.369	1.370	1.371			
N	2.495	2.505		2.496	2.499	2.498			
O	4.119	4.129		4.121	4.121	4.121			
P	0.115	0.135		0.127	0.125	0.125			
Q	0.115	0.135		0.135	0.135	0.135			
R	0.240	0.260		0.251	0.250	0.249			
S	0.115	0.135		0.115	0.115	0.116			
T	0.178	0.198		0.188	0.188	0.188			
U	3.210	3.250		3.230	3.230	3.230			
V	0.230	0.250		0.232	0.235	0.235			
W	0.115	0.135		0.124	0.124	0.124			
X	0.308	0.313		0.310	0.310	0.316			
Y	0.760	0.765		0.765	0.765	0.765			
Z	0.352	0.372		0.365	0.360	0.360			
AA	0.470	0.530		0.500	0.500	0.500			
AB	0.615	0.635		0.626	0.625	0.629			
AC	0.053	0.073		0.063	0.063	0.063			
AD	0.240	0.260		0.246	0.240	0.246			
AE	1.500	1.520		1.512	1.514	1.514			
AF	0.115	0.135		0.135	0.135	0.135			
AG	0.240	0.280		0.260	0.260	0.260			
AH	0.240	0.260		0.242	0.245	0.244			
AI	2.000	2.020		2.002	2.004	2.002			
AJ	0.023	0.043		0.033	0.030	0.030			
Accept/Reject									

Measured by: EP
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